Dart Aerospace Ltd.

Date: Wednesday, 6/27/2007 1:08:34 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: LUG ASSEMBLY
Job Number	: 33225		
Estimate Number	: 11745		
P.O. Number	: N/A	**Part Number**	: D3394043
This Issue	: 6/27/2007 **S.O. No.** : N/A	**Drawing Number**	: D3394 REV A
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : MACHINED PARTS	**Drawing Revision**	: A
Previous Run	: 33138	**Material**	: N/A
Written By	:	**Due Date**	: 7/18/2007 **Qty:** 40 **Um:** Each
Checked & Approved By	: 07.06.28		
Comment	: Est Rev: A New Issue 06-01-06 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion

Comment: Qty.: 0.0735 f(s)/Unit Total : 2.9400 f(s)
D2423 Lug Extrusion
Batch: 30062

Seq. #:	Machine Or Operation:	Description :
2.0	BAND SAW	BAND SAW

Comment: BAND SAW
Cut Blank to .850"

Seq. #:	Machine Or Operation:	Description :
3.0	OUTSIDE SERVICE	OUTSIDE SERVICES

Comment: Sub-Contracting OUTSIDE SERVICES
Send Blanks To:Metec/Mast Precision Machining CL 07/07/04 (40)
P/O: 4091
Machine D3394-3 as per Dwg D3394

Seq. #:	Machine Or Operation:	Description :
4.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage 7/7/19 (40)

Seq. #:	Machine Or Operation:	Description :
5.0	QC6	DIMENSIONAL CHECK

QSP019 counted

Comment: DIMENSIONAL CHECK 07/07/23 (x40)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ______ **Fault Category:** ________ **NCR:** Yes / No (circled: No) **DQA:** [signature] **Date:** 07/07/26

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

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Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: LUG ASSEMBLY

Job Number: 33225
Part Number: D3394043

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	FL 07/07/24 (40)
7.0	POWDER COATING	POWDER COATING
	M 105068	
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	BL / M 07-07-25 (40)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	FL 07/07/25 (40)
9.0	MS3548993	GROMMET
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s) Pick: Qty Part Number Description Batch 2 MS35489-93 Grommet M103688	7/7/25 SD
10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3394	ml 07/07/25 (x40)
11.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	07/07/26 (x40)
12.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST482	07/7/26 (40)
13.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	07/07/26 (40)

Job Completion — U 07/07/26

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

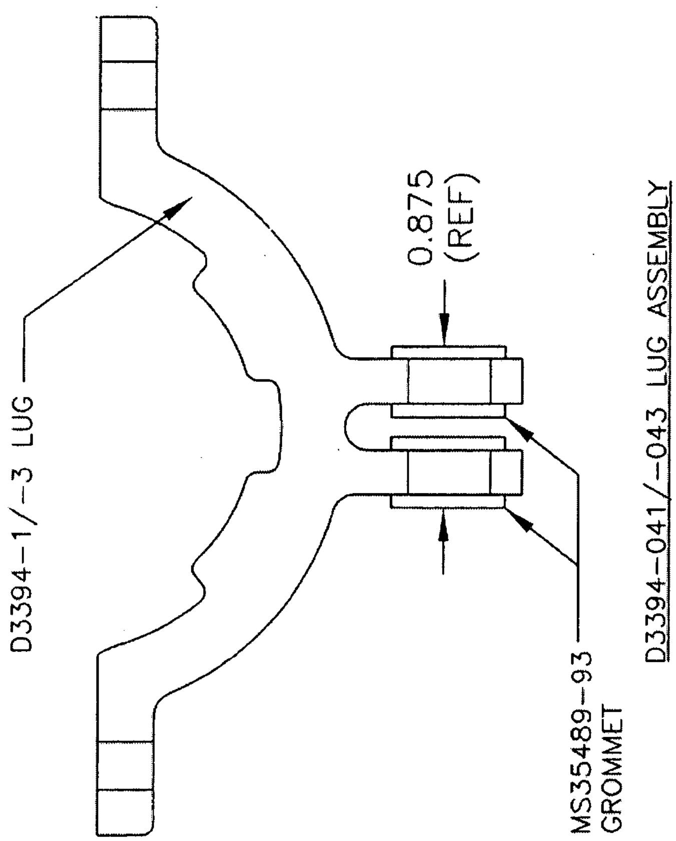
QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

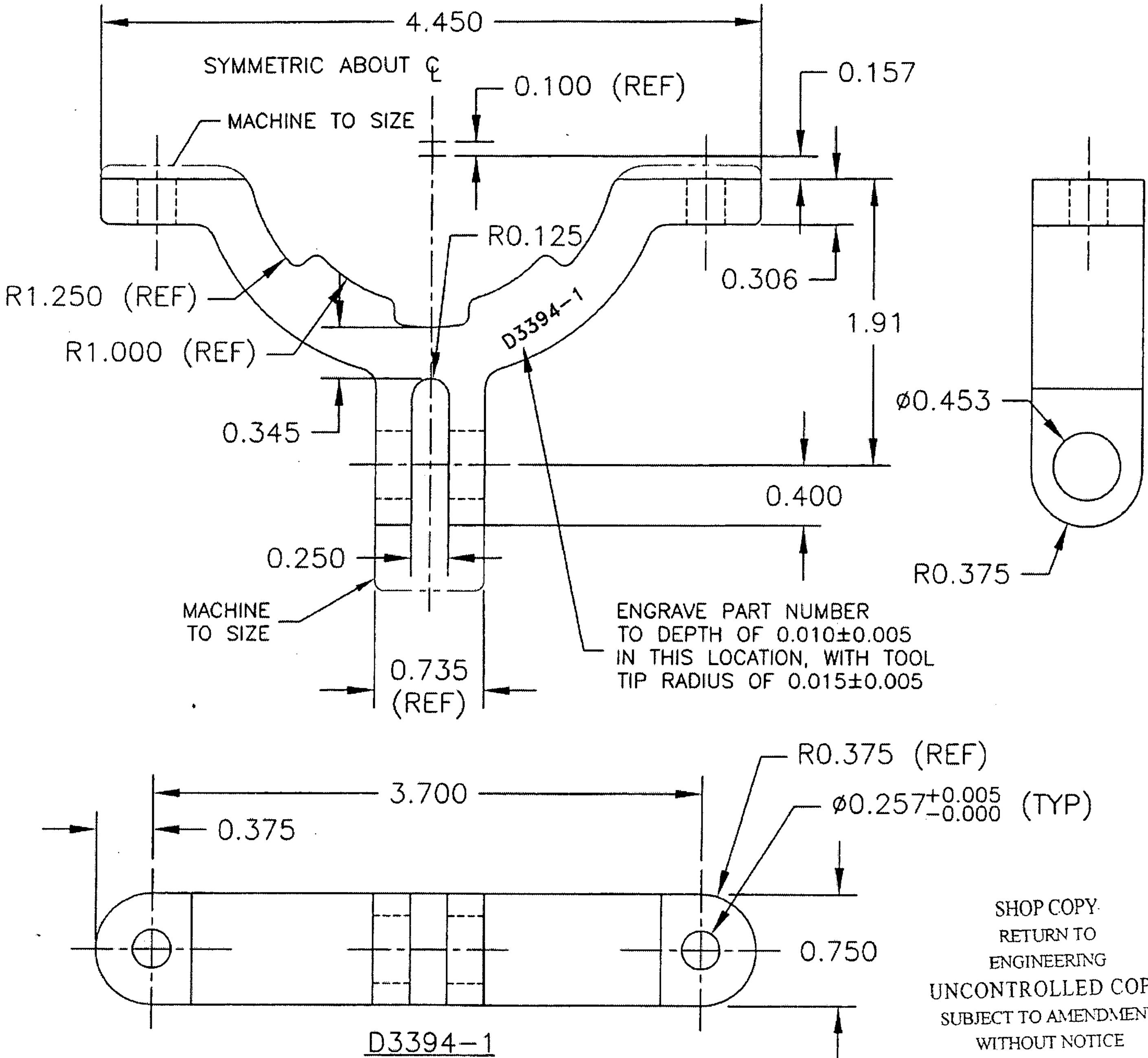
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
PH	PH		
CHECKED	APPROVED	DRAWING NO. D3394	REV. A SHEET 1 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1
A	05.02.14	NEW ISSUE	



PARTS LIST FOR D3394-041/-043 LUG ASSEMBLY

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3394-041	LUG ASSEMBLY
	X	D3394-043	LUG ASSEMBLY
1		D3394-1	LUG
	1	D3394-3	LUG
2	2	MS35489-93	GROMMET

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
PH	PH		
CHECKED	APPROVED	DRAWING NO. D3394	REV. A SHEET 2 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1



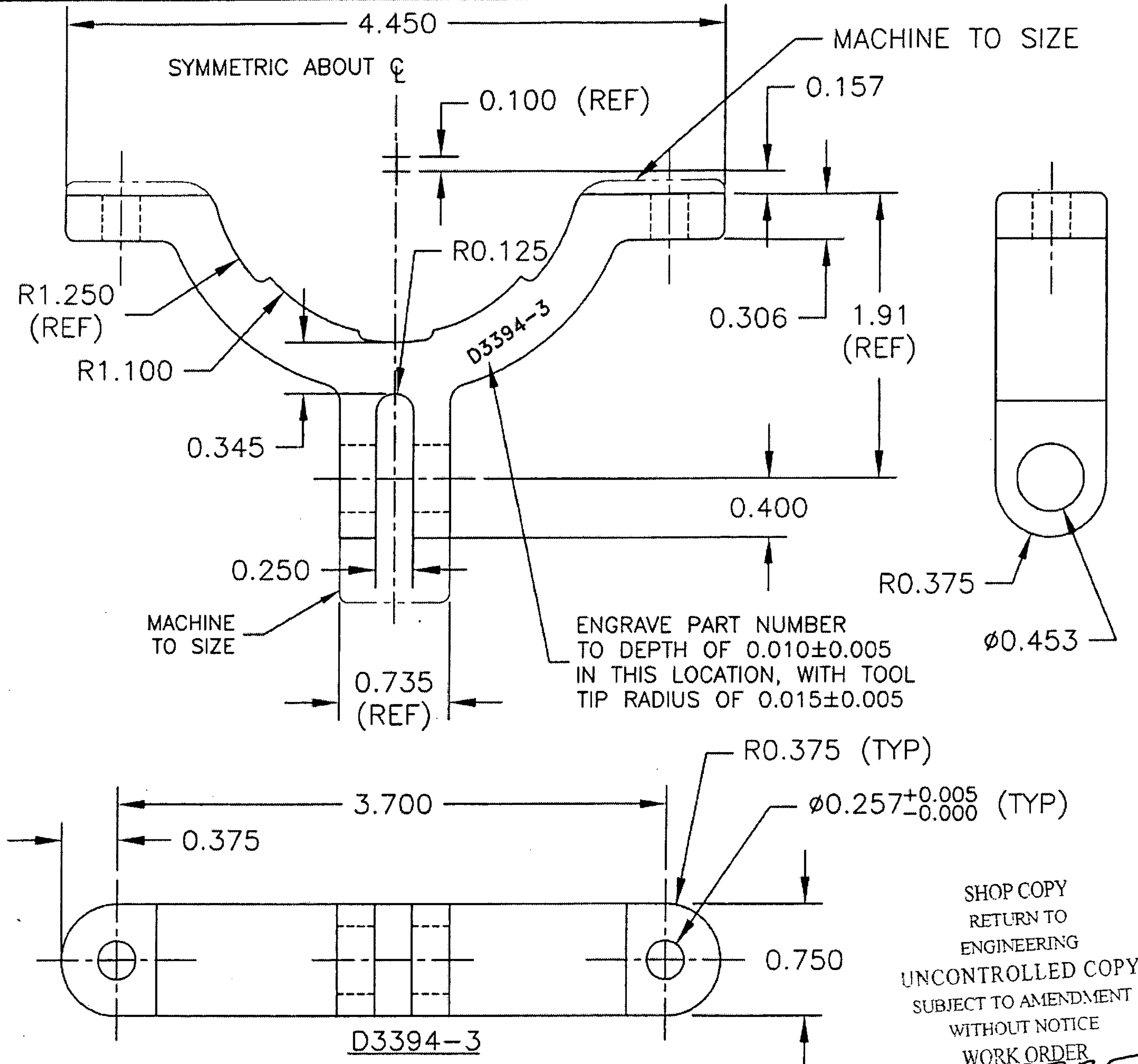
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33225

D3394-1 NOTES

1) MAKE FROM EXTRUSION D2423
2) BREAK ALL EDGES 0.000-0.015
3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
   POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.14

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3394 — REV. A — SHEET 3 OF 3
DATE 05.02.14		TITLE LUG — SCALE 1:1



SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 33225

D3394-3 NOTES
1) MAKE FROM EXTRUSION D2423
2) BREAK ALL EDGES 0.000-0.015
3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED 05.11.14

METEC METAL TECHNOLOGY INC.

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY	PART NUMBER	PART NAME	P.O. NUMBER
20	D3338-1	Mounting Lug B33248	4091
40	D3394-3	Mounting Lug B33225	4091

07/07/03

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, July 20, 2007

20 Terry Fox Drive P.O. Box 781 • Vankleek Hill ON K0B 1R0 • (613) 678-3957 Fax: (613) 678-3956